

Work Order ID 76100

ASAP
76100

Page 1

November-07-11 7:58:22 AM

Item ID: D2143

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Bracket

Start Date: 07/11/2011 Start Qty: 20.00

20

Cust Item ID:

Required Date: 21/11/2011 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: M.C.J Date: 11/11/07 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2143	Rev C1								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2143								
<u>5052.046</u>	Dwg Rev: <u>C1</u>								
	Prog Rev: <u>C1</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

11-11-30

(38)

11-11-30

11 11 30 (38)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Page 3

November-07-11 7:58:22 AM

Item ID: D2143 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Bracket
 Start Date: 07/11/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

170

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:20
3200 F
3:50

38 X M 11/12/05

180	QC3- Inspect Part Finish	0.00							
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180

QC

Quality Control

Memo

38 BK 11-12-5.

190	Identify as per dwg & Stock Location: 198	0.00							
-----	---	------	--	--	--	--	--	--	--

190

Packaging

Packaging

Memo

11/12/58 385

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

November-07-11 7:58:22 AM

Item ID: D2143 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Hinge Bracket
Start Date: 07/11/2011 Start Qty: 20.00 *20* Cust Item ID:
Required Date: 21/11/2011 Req'd Qty: 20.00 *20* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

11/12/16

me
11-12-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

November-07-11 7:58:26 AM

Page 1

Work Order ID: 76100

76100

Parent Item: D2143

D2143

Parent Item Name: Hinge Bracket

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP C00.05.18Added inspection level 8 EC

IPP Rev:D Now on WaterJet 06-10-15 JLM

IPP Rev:E

11.01.06 remove seq 130 (tumbling) DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.040

Purchased

No

100

sf

96.0000

0.066

1.389474

M5052H32S 040

11/11-30 2.5

5052-H32 .040 Sheet

Location

Loc Qty

Loc Code

MAT022

96

119384

96

119384

38

W/O:		WORK ORDER CHANGES					
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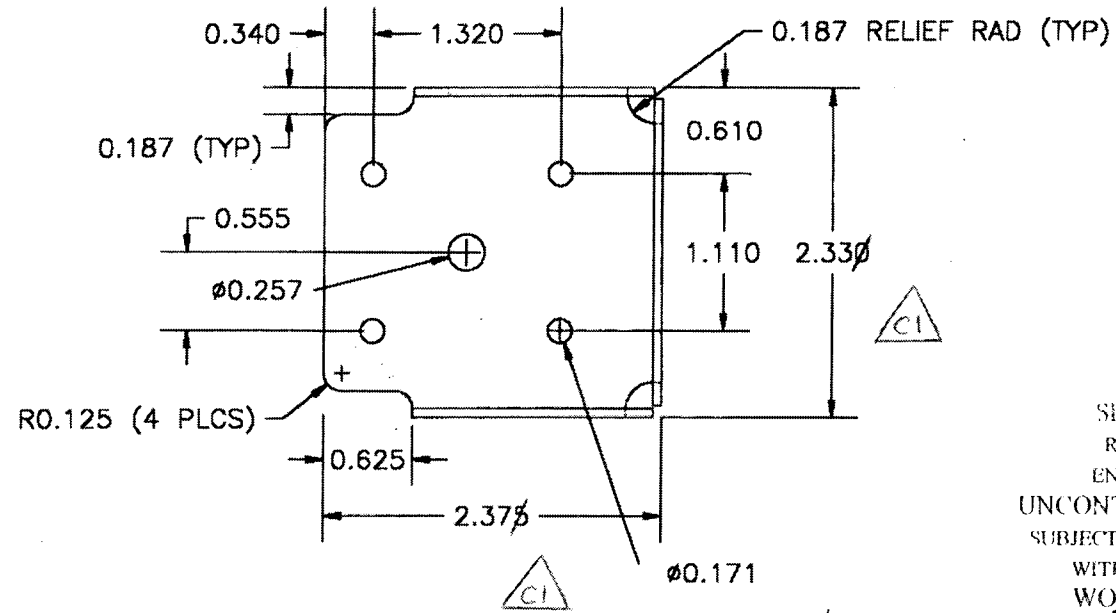
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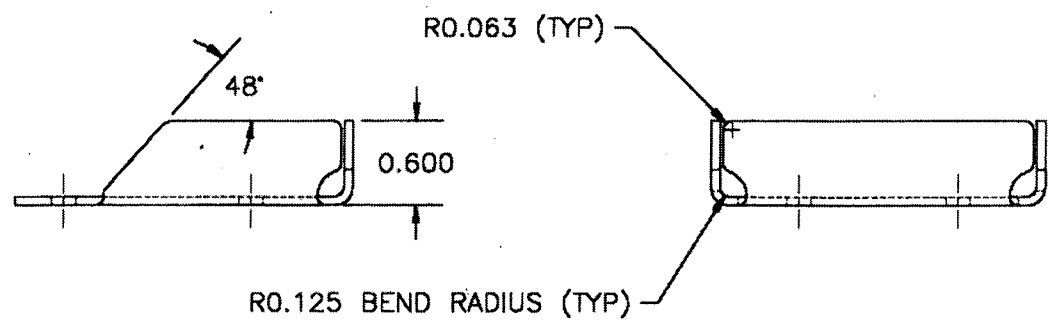


RELEASED
960620 13.0

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. C
J BRADLEY	K HAND	DRAWING NO. D2143	SHEET 1 OF 2
CHECKED B	APPROVED F	TITLE HINGE BRACKET	SCALE
DATE 92.07.10			
B	96.06.06	ADD FLAT PATTERN	
C	96.06.13	MATERIAL WAS 2024-T3 .063 THICK	
CI	04.06.15	UPDATE DIMENSIONS	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76100 H.L.D.
7/11/07



MATERIAL: 5052-H34, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

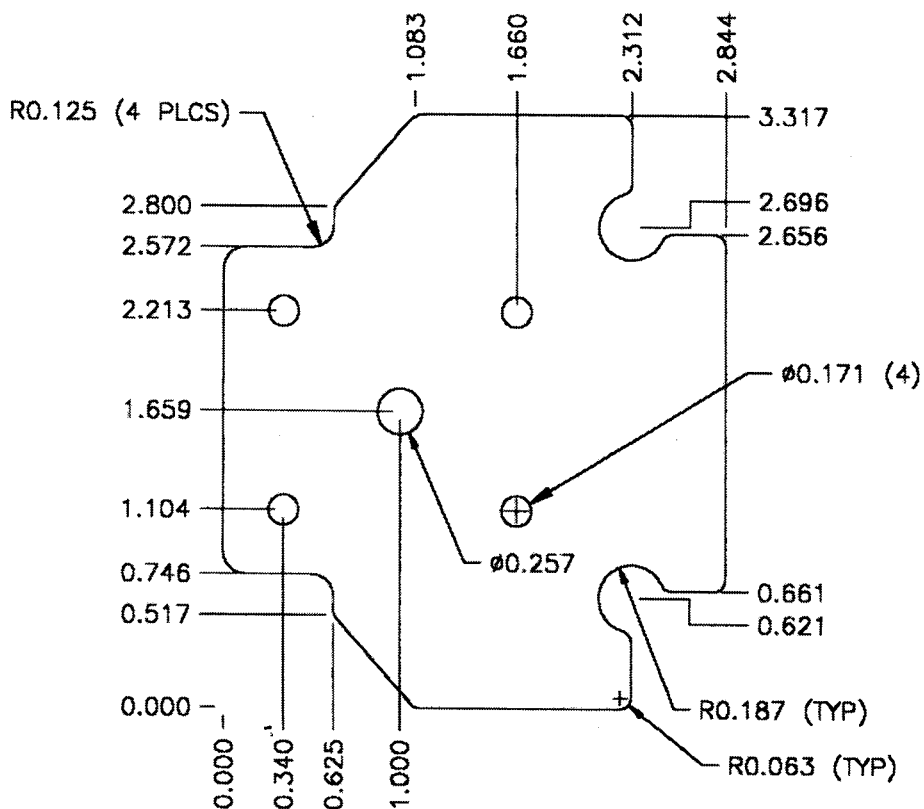
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NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
J BRADLEY	K HAND	DRAWING NO.	REV. a
CHECKED	APPROVED	D2143	SHEET 2 OF 2
DATE	TITLE		SCALE
95:10:18	HINGE BRACKET FLAT PATTERN		1:1

RELEASED
96 6b 20 b7



MATERIAL: 5052-H34, 0.040 THICK GRAIN ALONG 3.317

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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